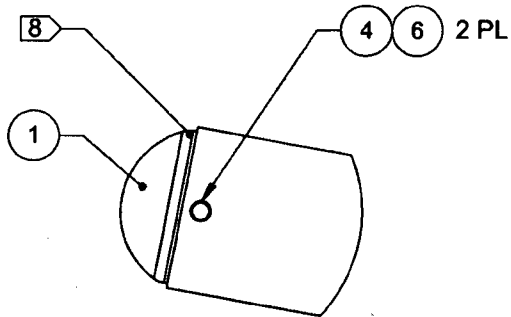
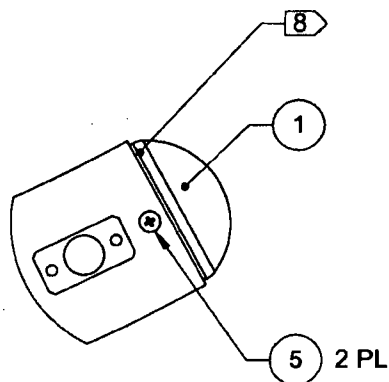


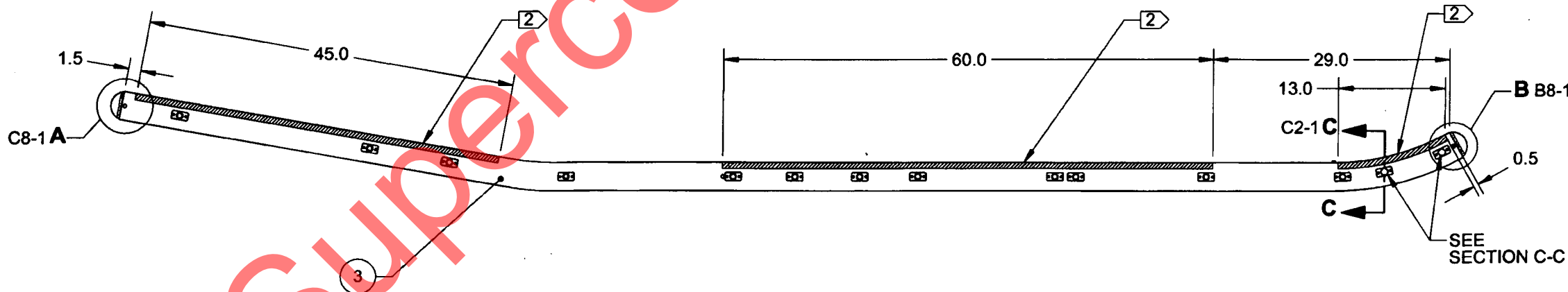
ITEM	QTY -041	P/N	DESCRIPTION
	X	D4766-041	SKIDTUBE
1	2	D2965	CAP
2	4	D3492-051	PLUG ASSY
3	1	D4766-043	SKIDTUBE SUB ASSY
4	2	AN3C5A	BOLT
5	2	AN526C1032-10	SCREW
6	2	AN960-10L	WASHER



**DETAIL A** B6-1  
SCALE 4X



**DETAIL B** B1-1  
SCALE 4X



**D4766-041 SKIDTUBE**

**UNDER REVIEW**

13.09.09

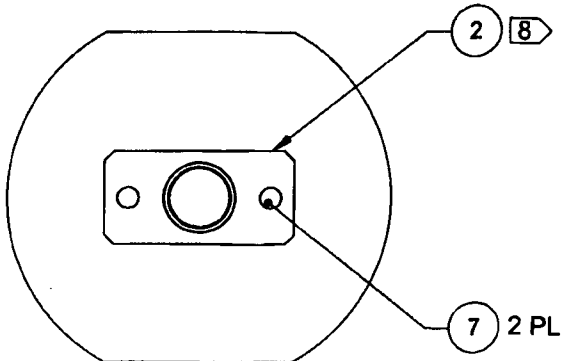
VARDA CHG-S

**RELEASED**  
2013-03-25

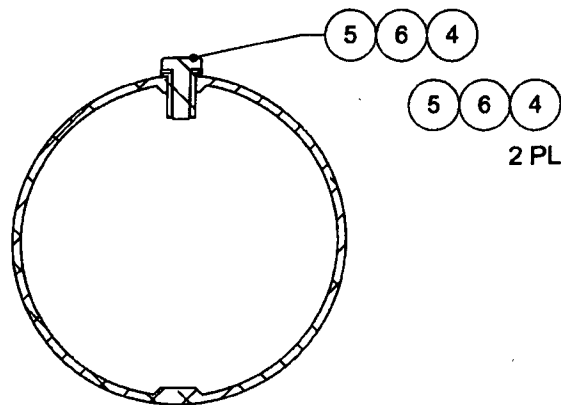
- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4.
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4766-041" AND B/N PER QSI 044 METHOD 6.4 ON INNER RADIUS OF SKIDTUBE BEFORE INSTALLING D2965 CAP
  - 7) WEIGHT: 31.81 lbs
  - 8) SEAL MATING SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT.

A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
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CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	MP	D4766	SHEET 1 OF 5
APPROVED	MP	TITLE	SCALE
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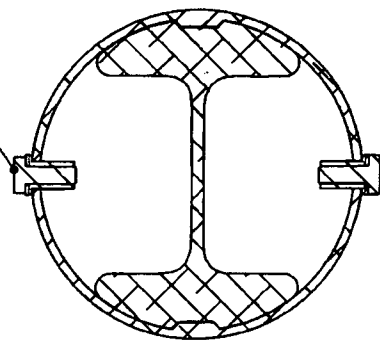
ITEM	QTY -043	P/N	DESCRIPTION
	X	D4766-043	SKIDTUBE SUB ASSY
1	14	D4686-1	SPACER
2	28	D4753-1	DOUBLER
3	1	D4766-045	SKIDTUBE SUB ASSY
4	3	AELS-1032-130	INSERT
5	3	AN3C4A	BOLT
6	3	AN960-10L	WASHER
7	56	MS20601AD4W3	RIVET



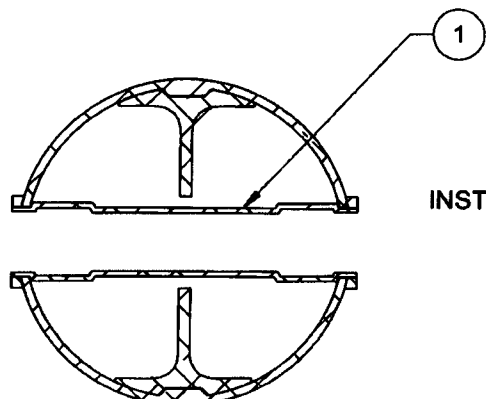
**DETAIL F** B4-2  
28 PL  
SCALE 6X



**SECTION E-E** B1-2  
SCALE 6X



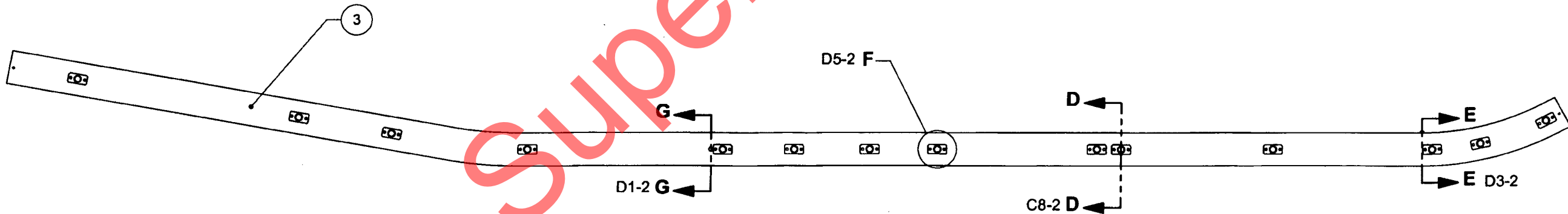
**SECTION G-G** B5-2  
SCALE 6X



**SECTION D-D** B3-2  
SCALE 6X

INSTALL D4686-1 SPACER AFTER INSTALLING D4753-1 DOUBLER AS FOLLOWS (14 PL)

1. INSERT D4686-1 SPACER
2. SWAGE TO  $\varnothing 0.661 \times 1.0$  DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



**D4766-043 SKIDTUBE SUB ASSY**

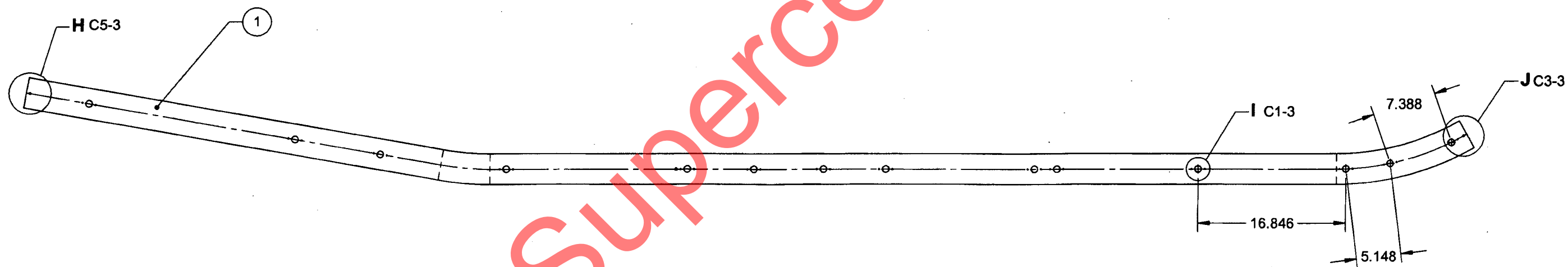
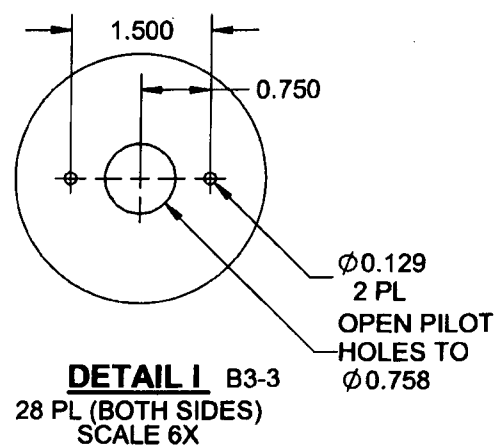
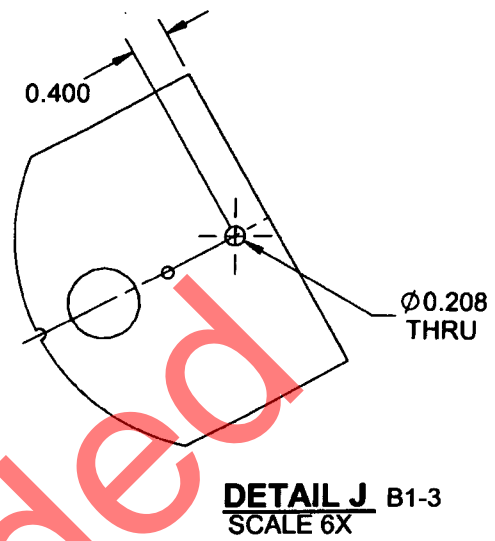
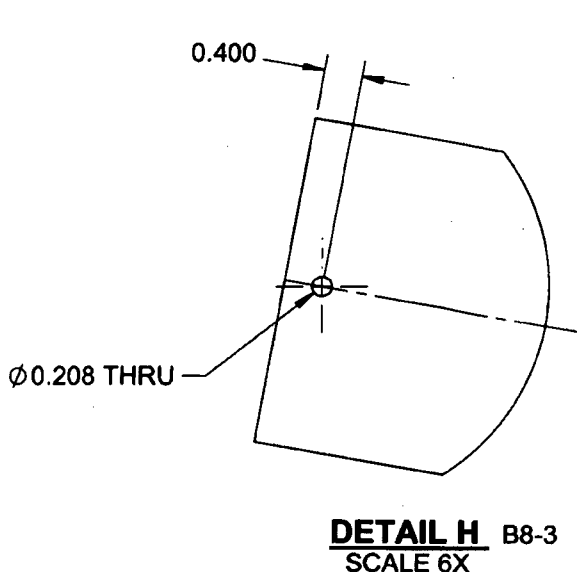
**UNDER REVIEW**  
13.09.09

**RELEASED**  
2013-03-25

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
APPLY SHERWIN WILLIAMS PRIMER (CM0483928) PER DART QSI 005 4.2  
PAINT TWO COATS OF SHERWIN WILLIAMS (CM0143603GA) GLOSS WHITE PER DART QSI 005 4.2  
APPLY TWO COATS OF SHERWIN WILLIAMS CLEAR COAT (CM0571080) PER DART QSI 005 4.2
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 31.15 lbs
  - 8) SEAL ALL FAYING SURFACES USING PROSEAL 890 B-2 (PRC)

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ITEM	QTY -045	P/N	DESCRIPTION
	X	D4766-045	SKIDTUBE SUB ASSY
1	1	D4766-1	SKIDTUBE
2	1	D4768-1	WEB



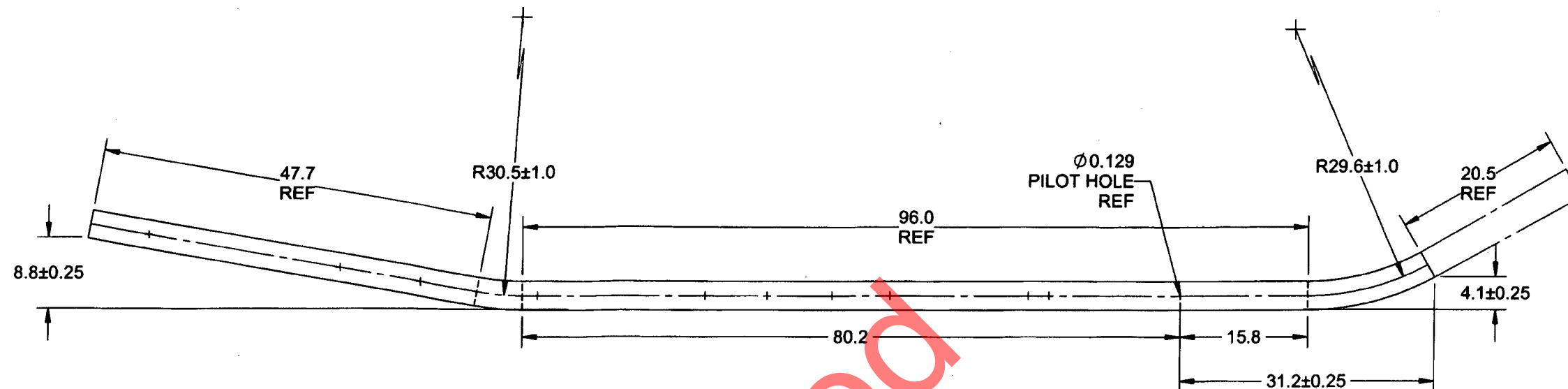
D4766-045 SKIDTUBE SUB ASSY  
(DRILLING DETAIL)

UNDER REVIEW  
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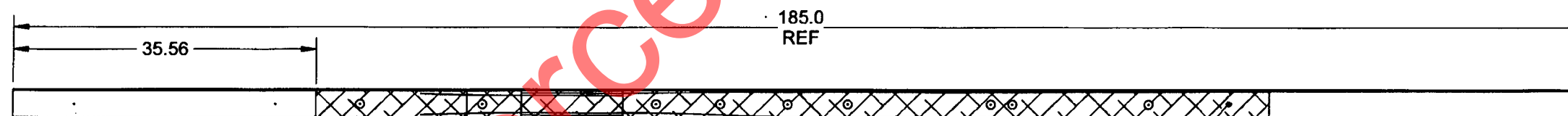
RELEASED  
2013-03-25

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 30.14 lbs

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**D4766-045 SKIDTUBE SUB ASSY**  
(BENDING DETAIL)



**SECTION K-K B8-4**  
SCALE 1/8

**D4766-045 SKIDTUBE SUB ASSY**  
(ASSEMBLY DETAIL)

UNDER REVIEW

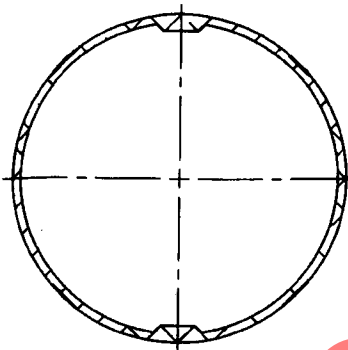
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11 2013-03-25

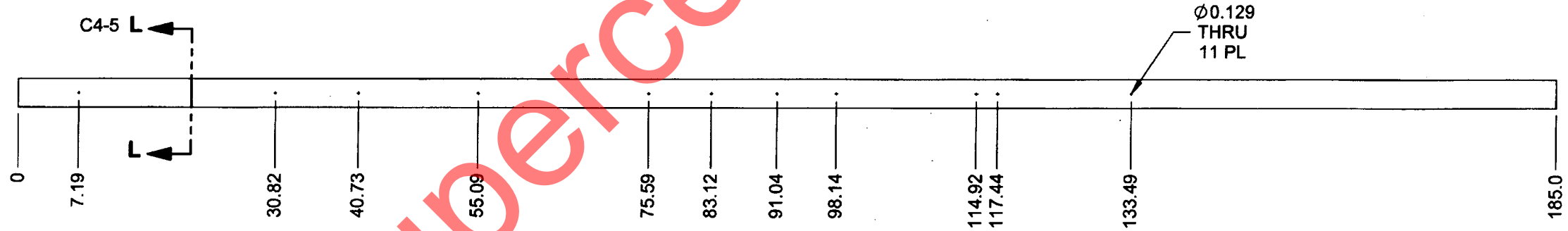
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 32.49 lbs
- 8) INSERT D4768-1 WEB INTO D4766-1 EXTRUSION IN LOCATION SHOWN AND BOND WEB INTO OUTER TUBE WITH NON STRUCTURAL SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015

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SECTION L-L B6-5  
SCALE 8X



D4766-1 SKIDTUBE C4-5

UNDER REVIEW  
13.09.09

RELEASED  
2013-03-25  
MP

- NOTES:
- 1) MATERIAL: MAKE FROM D2962-185 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 18.97 lbs

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